

# **SLOVENSKI STANDARD**

## **SIST EN 10219-2:2019**

**01-julij-2019**

**Nadomešča:**  
**SIST EN 10219-2:2006**

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**Hladno oblikovani varjeni votli konstrukcijski profili iz jekla - 2. del: Mere, mejni odstopki in značilnosti profilov**

Cold formed welded steel structural hollow sections - Part 2: Tolerances, dimensions and sectional properties

Kaltgefertigte geschweißte Hohlprofile für den Stahlbau aus unlegierten Baustählen und aus Feinkornbaustählen - Teil 2: Grenzabmaße, Maße und statische Werte

Profils creux de construction soudés, formés à froid en aciers non alliés et à grains fins - Partie 2 : Tolérances, dimensions et caractéristiques de profil

**Ta slovenski standard je istoveten z: EN 10219-2:2019**

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**ICS:**

77.140.45	Nelegirana jekla	Non-alloyed steels
77.140.70	Jekleni profili	Steel profiles

**SIST EN 10219-2:2019**

**en,fr,de**

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SIST EN 10219-2:2019

<https://standards.iteh.ai/catalog/standards/sist/05aed010-3419-4b34-a9b9-fba7fc5467c6/sist-en-10219-2-2019>

EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 10219-2**

May 2019

ICS 77.140.75

English Version

**Cold formed welded steel structural hollow sections - Part  
2: Tolerances, dimensions and sectional properties**

Profils creux de construction soudés, formés à froid en  
aciers - Partie 2 : Tolérances, dimensions et  
caractéristiques du profil

Kaltgeformte geschweißte Hohlprofile für den Stahlbau  
- Teil 2: Grenzabmaße, Maße und statische Werte

This European Standard was approved by CEN on 20 March 2019.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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## European foreword

This document (EN 10219-2:2019) has been prepared by Technical Committee CEN/TC 459 “ECISS - European Committee for Iron and Steel Standardization”<sup>1</sup>, the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by November 2019, and conflicting national standards shall be withdrawn at the latest by November 2019.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 10219-2:2006.

The main changes with respect to the previous edition are listed below:

- a) elliptical hollow sections were added;
- b) Annex A concerning the additional tolerances for piling tubes was removed;
- c) subclause 5.2 was added with one option;
- d) in Table 3 the length tolerances for exact length were changed;
- e) in 7.1 one paragraph was added;
- f) standard was editorially revised.

This standard consists of the following parts:

- EN 10368, *Steel structural hollow sections – General (Characteristics, evaluation of conformity and marking)* (in preparation)
- EN 10219-1, *Cold formed welded steel structural hollow sections - Part 1: Technical delivery conditions*
- EN 10219-2, *Cold formed welded steel structural hollow sections - Part 2: Tolerances, dimensions and sectional properties*
- EN 10219-3, *Cold formed welded steel structural hollow sections - Part 3: Technical delivery conditions for mechanical engineering purposes* (in preparation)

It forms part of a series of standards on hollow sections together with EN 10210-1 to EN 10210-3.

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

<sup>1</sup> Through its subcommittee SC 3 “Structural steels other than reinforcements” (secretariat: DIN)

## EN 10219-2:2019 (E)

## 1 Scope

This document specifies tolerances for cold formed welded circular, square, rectangular and elliptical structural hollow sections, manufactured in wall thicknesses up to 40 mm, in the following size ranges:

- circular: Outside diameters up to 2 500 mm;
- square: Outside dimensions up to 500 mm × 500 mm;
- rectangular: Outside dimensions up to 500 mm × 300 mm;
- elliptical: Outside dimensions up to 480 mm × 240 mm.

The formulae for calculating sectional properties of sections manufactured to the dimensional tolerances of this standard, to be used for the purposes of structural design, are given in Annex A.

Dimensions and sectional properties for a limited range of more common sizes are given in Annex B.

NOTE The designation of the sections' major axis (yy) and minor axis (zz) aligns with the axis designation used for structural design in the structural Eurocodes.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 10219-1, *Cold formed welded structural hollow sections of non-alloy and fine grain steels — Part 1: Technical delivery conditions*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 10219-1 apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

## 4 Symbols

For the purposes of this document, the symbols defined in Table 1 apply.

**Table 1 — Symbols and definitions**

Symbol	Unit	Definition
$A$	cm <sup>2</sup>	Cross-sectional area
$A_m$	mm <sup>2</sup>	Area of the surface delimited by the perimeter at mid-thickness
$A_s$	m <sup>2</sup> /m	Superficial area per metre length
$B$	mm	Specified side dimension of a square hollow section. Specified dimension of the shorter side of a rectangular hollow section. Specified outside dimension of an elliptical section on its minor axis
$C_1/C_2$	mm	Length of corner region of a square or rectangular hollow section

Symbol	Unit	Definition
$C_t$	cm <sup>3</sup>	Torsional modulus constant
$D$	mm	Specified outside diameter of a circular hollow section
$D_{\max}/D_{\min}$	mm	Maximum and minimum outside diameter of a circular hollow section measured in the same plane
$e$	mm	Deviation from straightness
$H$	mm	Specified dimension of the longer side of a rectangular hollow section. Specified outside dimension of an elliptical section on its major axis
$I$	cm <sup>4</sup>	Second moment of area
$I_t$	cm <sup>4</sup>	Torsional inertia constant (polar moment of inertia in the case of circular hollow sections only)
$i$	cm	Radius of gyration
$L$	mm	Length
$M$	kg/m	Mass per unit length
$O$	%	Out-of-roundness
$P$	mm	External perimeter of an elliptical hollow section
$R$	mm	External corner radius of a square or rectangular hollow section
$T$	mm	Specified thickness
$U$	mm	Perimeter of an elliptical hollow section at mid-thickness
$V$	mm	Total measured twist
$V_1$	mm	Twist measured at one end of a section
$W_{el}$	cm <sup>3</sup>	Elastic section modulus
$W_{pl}$	cm <sup>3</sup>	Plastic section modulus
$x_1$	mm	Concavity of a side of a square or rectangular hollow section
$x_2$	mm	Convexity of a side of a square or rectangular hollow section
$yy$	—	Axis of cross-section, major axis of a rectangular hollow section
$zz$	—	Axis of cross-section, minor axis of a rectangular hollow section
$\theta$	°	Angle between adjacent sides of a square or rectangular hollow section

## 5 Information to be obtained by the manufacturer

### 5.1 Mandatory information

The following mandatory information from this part of EN 10219 shall be obtained by the manufacturer at the time of enquiry and order:

- the dimensions (see Clause 8);
- the type of length, length range or length (see Table 4);

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NOTE This information is included in the list of information to be obtained by the manufacturer contained in EN 10219-1.

## 5.2 Options

An option is specified in this part of EN 10219. In the event that the purchaser does not indicate a wish to implement this at the time of enquiry and order, the manufacturer shall supply in accordance with the basic specification.

Option 2.1 Out-of-roundness tolerances for diameter to thickness ratio exceeding 100 (see Table 2, footnote a).

## 6 Tolerances

6.1 Tolerances shall not exceed the values given in Table 2 for shape and mass, Table 3 for external corner profiles, Table 4 for manufacturer's delivered length and Table 5 for the height of the internal and external weld bead of submerged arc welded hollow sections.

6.2 The internal corners of square and rectangular hollow sections shall be rounded.

NOTE The internal corner profile is not specified.

Table 2 — Tolerances on shape, straightness and mass

Characteristic	Circular hollow sections	Square and rectangular hollow sections		Elliptical hollow section
		Side length mm	Tolerance	
Outside dimensions ( $D$ , $B$ and $H$ )	$\pm 1\%$ with a minimum of $\pm 0,5$ mm and a maximum of $\pm 10$ mm	$H$ , $B < 100$  $100 \leq H$ , $B \leq 200$  $H$ , $B > 200$	$\pm 1\%$ with a minimum of $\pm 0,5$ mm  $\pm 0,8\%$  $\pm 0,6\%$	$\pm 1\%$ with a minimum of $\pm 0,5$ mm
Thickness ( $T$ )	For $D \leq 406,4$ mm: $T \leq 5$ mm $\pm 10\%$ $T > 5$ mm $\pm 0,5$ mm For $D > 406,4$ mm: $\pm 10\%$ with a maximum of $\pm 2$ mm	$T \leq 5$ mm $\pm 10\%$ $T > 5$ mm $\pm 0,5$ mm		$T \leq 5$ mm $\pm 10\%$ $T > 5$ mm $\pm 0,5$ mm
Out-of-roundness ( $O$ )	2 % for hollow sections having a diameter to thickness ratio not exceeding 100 <sup>a</sup>	—		—
Concavity/convexity ( $x_1, x_2$ ) <sup>b</sup>	—	Max. 0,8 % with a minimum of 0,5 mm		—



Characteristic	Circular hollow sections	Square and rectangular hollow sections		Elliptical hollow section
		Side length mm	Tolerance	
Squareness of side ( $\theta$ )	—	90° ± 1°		—
External corner profile ( $C_1$ , $C_2$ or $R$ )	—	See Table 3		—
Twist ( $V$ )	—	2 mm plus 0,5 mm/m length		—
Straightness ( $e$ )	0,20 % of total length and 3 mm over any 1 m length	0,15 % of total length and 3 mm over any 1 m length		0,20 % of total length and 3 mm over any 1 m length
Mass per unit length ( $M$ )	±6 % on individual delivered lengths			
<p><sup>a</sup> When the diameter to thickness ratio exceeds 100, application of tolerance on out-of-roundness is not required, unless specifically agreed (see 5.2).</p> <p><sup>b</sup> The tolerance on convexity and concavity is independent of the tolerance on outside dimensions.</p>				

### Table 3 — Tolerances on external corner profiles

Dimensions in millimetres

Thickness $T$	External corner profile $C_1$ , $C_2$ or $R$ <sup>a</sup>
$T \leq 6$	1,6 $T$ to 2,4 $T$
$6 < T \leq 10$	2,0 $T$ to 3,0 $T$
$10 < T$	2,4 $T$ to 3,6 $T$
<sup>a</sup> The sides need not be tangential to the corner arcs.	

Table 4 — Tolerances on manufacturer's delivered length

Dimensions in millimetres

Type of length <sup>a</sup>	Range of length or length $L$	Tolerance
Random length	$4\,000 < L \leq 16\,000$ with a range of 2 000 per order item	10 % of sections supplied may be below the minimum for the ordered range but not shorter than 75 % of the minimum range length
Approximate length	$\geq 4\,000$	$+50_0$ mm
Exact length <sup>b</sup>	$< 6\,000$	$+10_0$ mm
	$6\,000 \leq L \leq 10\,000$	$+15_0$ mm
	$> 10\,000$	$+5_0$ mm + 1 mm/m
<sup>a</sup> The manufacturer shall establish at the time of enquiry and order the type of length required and the length range or length. <sup>b</sup> Common lengths available are 6 m and 12 m.		

Table 5 — Tolerance on height of internal and external weld seam for submerged arc welded hollow sections

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<https://standards.iteh.ai/catalog/standards/sist/05aed010-3419-4b34-2019-fba71c5467c6/sist-en-10219-2-2019> Dimensions in millimetres

Thickness, $T$	Maximum weld bead height
$\leq 14,2$	3,5
$> 14,2$	4,8

## 7 Measurement of size and shape

### 7.1 General

All external dimensions, including out-of-roundness, shall be measured at a distance from the end of the hollow section of not less than  $D$  for circular sections,  $B$  for square sections or  $H$  for rectangular and elliptical sections, with a minimum of 100 mm.

All dimensional and shape tolerances indicated in Tables 2, 3 and 5 shall be verified according to a procedure fixed by the manufacturer.

### 7.2 Outside dimensions

For circular hollow sections the diameter ( $D$ ) and for elliptical hollow sections the outside dimensions ( $B$  and  $H$ ) shall be measured either directly, e.g. using a calliper gauge, or for circular tubes by circumference tape at the discretion of the manufacturer.

The limiting cross-sectional positions for measuring  $B$  and  $H$  for square and rectangular hollow sections are shown in Figure 1.

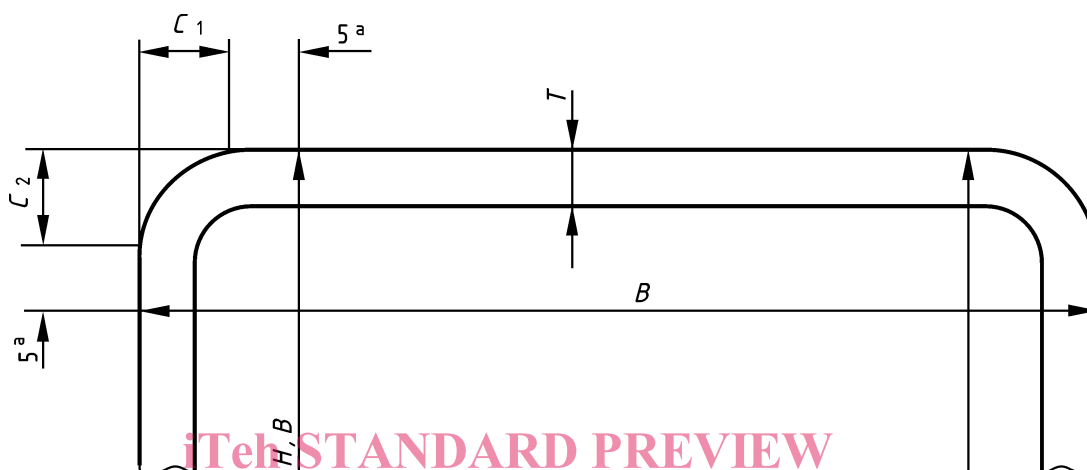
### 7.3 Thickness

The thickness ( $T$ ) shall be measured at a position not less than  $2T$  from the weld.

The limiting cross-sectional positions for measuring the thickness of square and rectangular hollow sections are shown in Figure 1.

NOTE Thickness is normally measured within a distance of half the outside diameter or half the dimension of the longer side from the end of the section.

Dimensions in millimetres



#### Key

<sup>a</sup> This dimension is a maximum when measuring  $B$  or  $H$  and a minimum when measuring  $T$

**Figure 1 — Limiting cross-sectional positions for measuring the dimensions  $B$ ,  $H$  and  $T$  for square or rectangular hollow sections**

### 7.4 Out-of-roundness

The out-of-roundness ( $O$ ) of a circular hollow section shall be calculated from the following formula:

$$O(\%) = \frac{D_{\max} - D_{\min}}{D} \times 100$$

### 7.5 Concavity and convexity

The concavity ( $x_1$ ) or the convexity ( $x_2$ ) of the sides of a square or rectangular hollow section shall be measured as shown in Figure 2.

The percentage concavity or convexity shall be calculated as follows:

$$\frac{x_1}{B} \times 100\%; \frac{x_2}{B} \times 100\%; \frac{x_1}{H} \times 100\%; \frac{x_2}{H} \times 100\%$$

where  $B$  and  $H$  are the dimensions of the sides containing the concavity  $x_1$  or the convexity  $x_2$ .

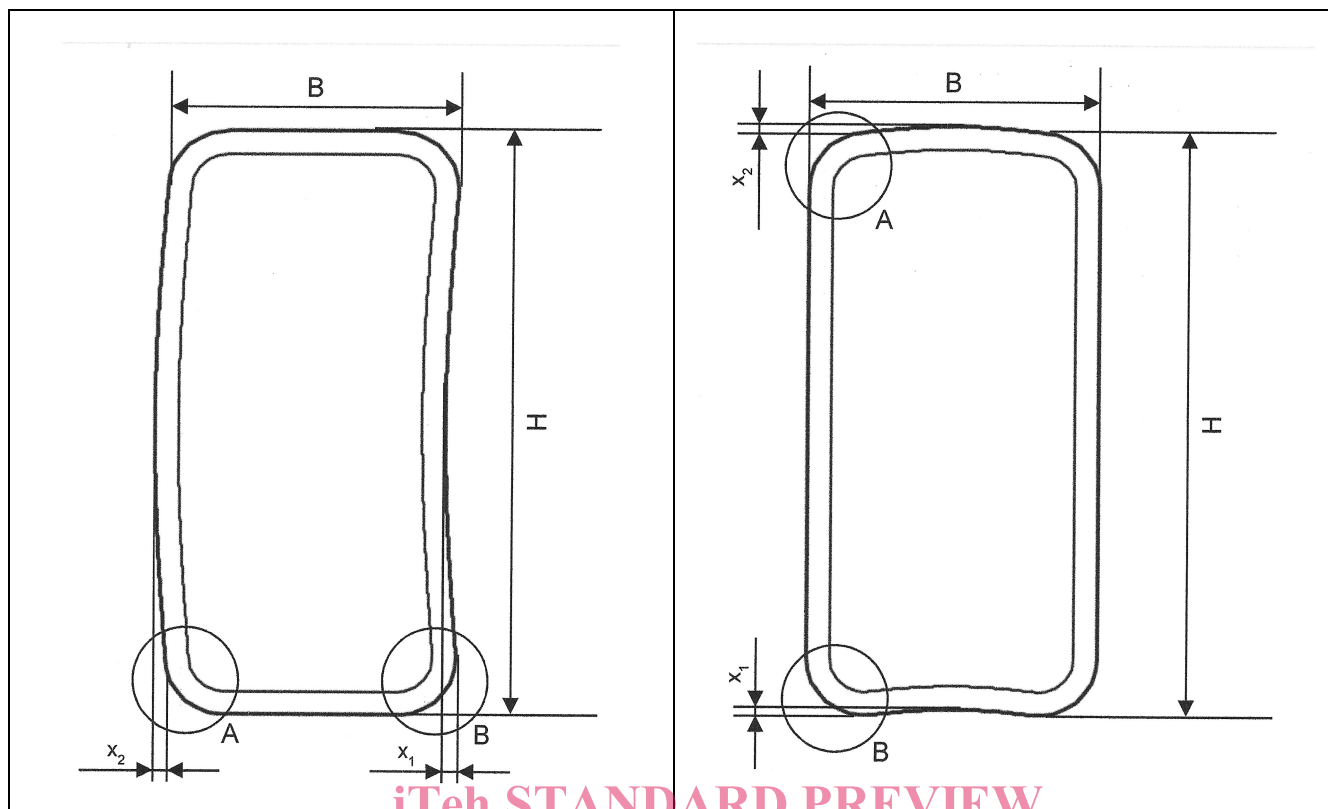


Figure 2 — Measurement of concavity/convexity of square or rectangular hollow sections

## 7.6 Squareness of sides

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<https://standards.iteh.ai/catalog/standards/sist/05aed010-3419-4b34-a9b9-787ff5467c66/sist-en-10219-2-2019>

The deviation from squareness of the sides of a square or rectangular hollow section shall be measured as the difference between  $90^\circ$  and  $\theta$  as shown in Figure 3.

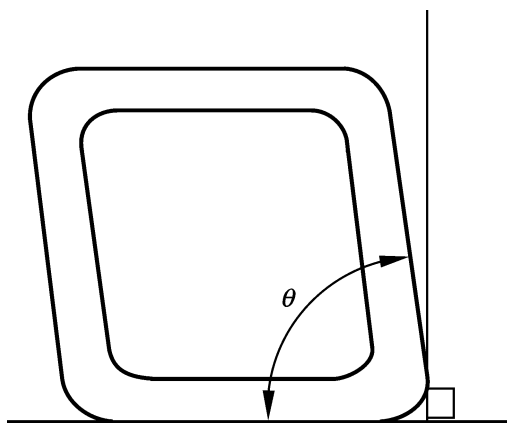


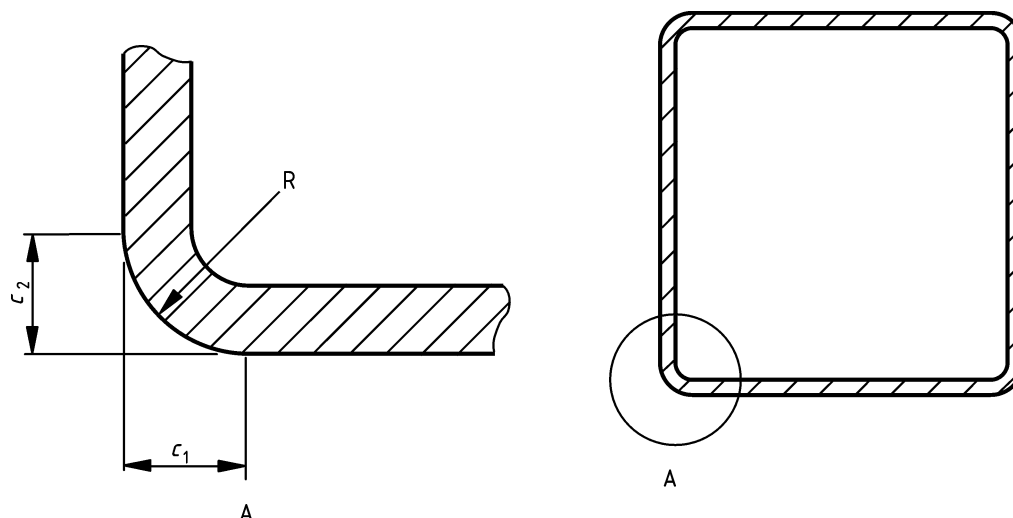
Figure 3 — Squareness of sides of square or rectangular hollow sections

## 7.7 External corner profile

7.7.1 The external corner profile of a square or rectangular hollow section shall be measured according to 7.7.2 or 7.7.3 at the discretion of the manufacturer.

7.7.2 The corner arc shall be measured with a radius gauge.

**7.7.3** The distance between the intersection of the flat side and the corner arc and the intersection of the projections of the flat sides to the corner ( $C_1$  and  $C_2$  in Figure 4) shall be measured.

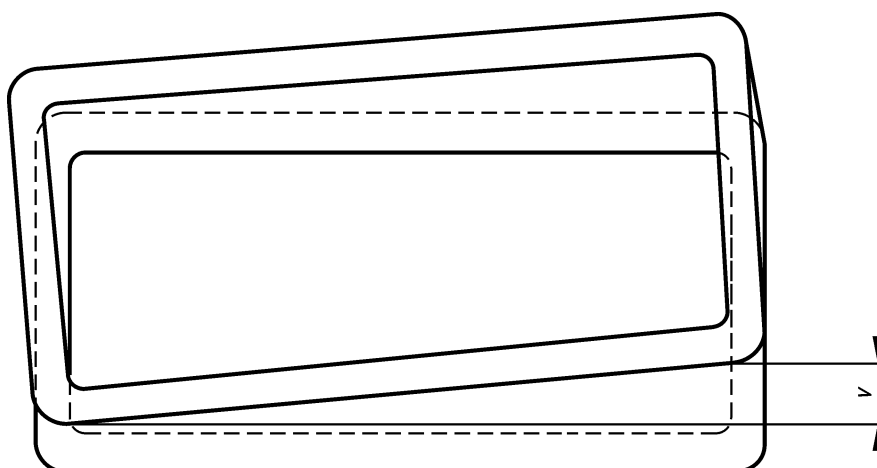


**Figure 4 — Outside corner profile of square or rectangular hollow sections**

## 7.8 Twist

**7.8.1** The twist ( $V$ ) in a square or rectangular hollow section shall be determined in accordance with 7.8.2 or 7.8.3 at the discretion of the manufacturer. The twist ( $V$ ) in an elliptical hollow section shall be determined in accordance with 7.8.4.

**7.8.2** The hollow section shall be placed on a horizontal surface with one side at one end pressed flat against the surface. At the opposite end of the hollow section the difference in height of the two lower corners from the horizontal surface (see Figure 5) shall be determined.



**Figure 5 — Twist of square or rectangular hollow sections**

**7.8.3** The twist of square and rectangular hollow sections shall be measured with a spirit level and micrometer gauge (screw). The reference length of the spirit level shall be the distance between the intersection of the flat sides and the corner arcs (see Figure 6). The twist  $V$  is the difference between the values  $V_1$  (see Figure 6) measured at each end of the hollow section.